

Work Order ID 95563

95563

Page 1

Item ID: D4016-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Half, Lid

Start Date: 1/11/13 Start Qty: 18.00

18

Cust Item ID:

Required Date: 1/17/13 Req'd Qty: 18.00

18

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 13-01-11

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4016

A

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK as per folio

on 13/01/15

18

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA874 AND DWG

FOLIO REV: 44

DWG REV: 4

DEBURR

D4016
25
13-01-15

Work Order ID 95563

January-11-13 2:05:33 PM

95563

Page 2

Item ID: D4016-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Half, Lid

Start Date: 1/11/13 Start Qty: 18.00

18

Cust Item ID:

Required Date: 1/17/13 Req'd Qty: 18.00

18

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***


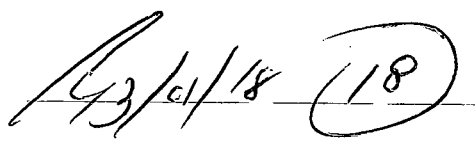
QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		13/01/16		13	6		
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>u2004</u> Memo	0.00 0.00							

Work Order ID 95563***95563***

Page 3

Item ID: D4016-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Hinge Half, Lid

Stop ***NS2***

Start Date: 1/11/13 Start Qty: 18.00

18

Cust Item ID:

Required Date: 1/17/13 Req'd Qty: 18.00

18

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

13/1/23
P/B-0148

Picklist Print

January-11-13 2:05:36 PM

Page 1

Work Order ID: 95563

95563

Parent Item: D4016-3

D4016-3

Parent Item Name: Hinge Half, Lid

Start Date: 1/11/13

Required Date: 1/17/13

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	9.0600	0.08	1.515789			

M304B1 000X1 000

304 bar 1.00 x 1.00

**

Location

Loc Qty

Loc Code

MAT049

9.06

122008

9.06

1.52 *OK 13/01/05*

DART AEROSPACE LTD		Work Order:	95563
Description: Hinge Half, Lid		Part Number:	D4016-3
Inspection Dwg: D4016 Rev: A		Page 1 of 1	

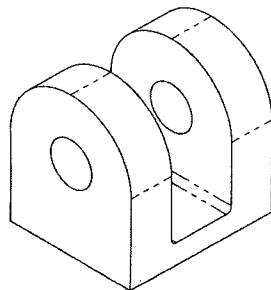
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	0.878	/		pin SL-10	
0.13	+/-0.030	0.127	/			
0.250	+/-0.010	0.249	/			
R0.03	+/-0.030	0.03	/			
0.13	+/-0.030	0.126	/			
0.50	+/-0.030	0.499	/			
0.63	+/-0.030	0.627	/			
0.563	+/-0.010	0.565	/			
Ø0.257	+0.006/-0.001	0.257	/			

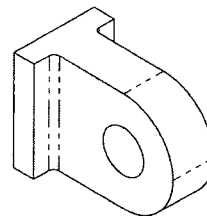
Measured by: SL	Audited by: [Signature]	Preliminary Approval:
Date: 13-01-15	Date: 13/01/16	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ [Signature]	[Signature]

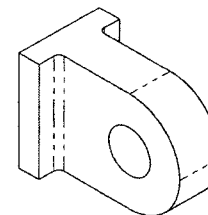
95563 MLS
13-05-11



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

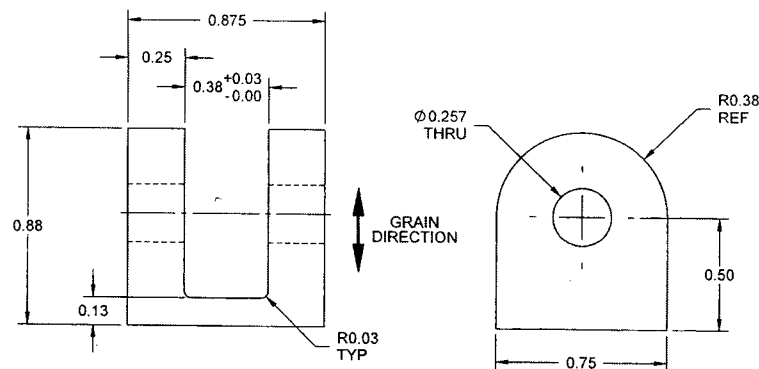


D4016-5 HINGE HALF, LIGHT LID

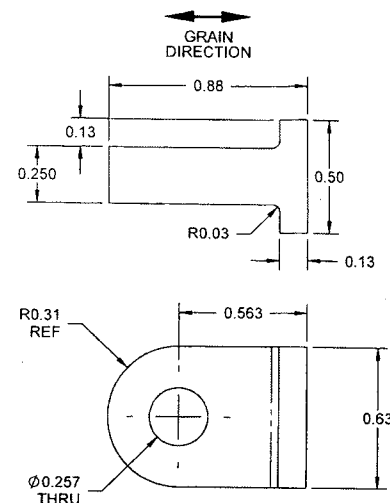
RELEASED
2010-02-16
MD

A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	[Signature]	DRAWING NO.	REV. A
MFG. APPR.	[Signature]	D4016	SHEET 1 OF 2
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

95563



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16
AM

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4016	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET HINGE	NTS
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	